

540

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24204
<b>Description:</b> Hi - Step Leg Assembly		<b>Part Number:</b>	D3065-041
<b>Dwg:</b> D3065 Rev. A1 A2 RF 03.02.17 RF 03.02.28		<b>Qty:</b>	30 4
		Page 1 of 2	

Qty 131

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.04 (Minimum lots of 30)	AL	05/09/07	30
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17948 Identify as D3065-1 4.320" RF 02.11.29 4.320"	J.L	05.09.27	30
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250" RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17948 02.11.13 02.11.29	J.L	05.09.28	30
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17948 Identify as D3065-7	J.L	05.09.27	30
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M18388 Identify as D3065-5 (Note: make 2 legs per assembly)	J.L	05.09.28	60
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M18388 Identify as D3066-1 (Note: make 2 spacers per assembly) M17400	J.L	05.10.06	60
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	J.L	05.10.02	30
8	MV	Deburr to take measurement	J.L	05.10.02	30
9	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	30
10	QC8	Second check	J.L	05.10.02	30
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	J.L	05.10.02	30
12	MV	Deburr to take measurement	J.L	05.10.02	30
13	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	30
14	QC8	Second check	J.L	05.10.02	30
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	J.L	05.10.02	30
16	MV	Deburr to take measurement	J.L	05.10.02	30
17	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.02	30
18	QC8	Second check	J.L	05.10.02	30
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	J.L	05.10.02	30

58.9

224

05.03.09  
#4

RELEASED  
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/00

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24204
<b>Description:</b> Hi - Step Leg Assembly		<b>Part Number:</b>	D3065-041
RF 03.02.28			
<b>Dwg:</b> D3065 Rev. A1 A2		<b>Qty:</b>	30
RF 03.02.17			Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	J.L	05.10.03	60																								
20	MV	Deburr to take measurement	J.L	05.10.03	60																								
21	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.03	60																								
22	QC8	Second check	EP	05/10/03	60																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	J.L	05.10.06	60																								
24	MV	Deburr to take measurement	J.L	05.10.06	60																								
25	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.06	60																								
26	QC8	Second check	EP	05/10/06	60																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.	SB	05/10/26	30																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 30 30 30	SB	05/10/26	30																								
29	QC5	Inspect work to Step 28	J	05.10.27	30																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	DL	05/10/27	30																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B 24204</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B 24204</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>B 24204</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B 24204</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M 17405</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B 24204	1	D3065-3	Spacer	B 24204	2	D3065-5	Leg	B 24204	1	D3065-7	Spacer	B 24204	30	MS20470AD4-4	Rivet	M 17405	SB	05/11/02	30
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B 24204																										
1	D3065-3	Spacer	B 24204																										
2	D3065-5	Leg	B 24204																										
1	D3065-7	Spacer	B 24204																										
30	MS20470AD4-4	Rivet	M 17405																										
32	QC5	Inspect work to Step 31	J	05.11.07	30																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	SB	05/11/07	30																								
34	AC	Cost / part 44.44	JAC	05.11.10	36																								
35	DC	Close W/O 40.94 Inspect Level 21	J	05/11/08	30																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

**RELEASED**  
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
	28							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_













# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 02, 2005  
09:01 am

Work Order No : 0024204  
Project Name : D3065-041  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3065-041  
Description : Step Leg Assembly  
Manufactured : Yes  
Amount Req'd : 20 30  
Amount Done : 0  
Start Date : 09-01-05  
Est Finish Date : 10-06-05  
Act Finish Date :  
Drawings Req'd : NO  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
11:10 am

Work Order No : 0024204  
Project Name : D3065-041  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3065-041  
Description : Step Leg Assembly  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 09-01-05  
Est Finish Date : 10-06-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	55.62	100.00		
Production Cost :	0.00	1043.05	100.00	0.00	1043.05
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	17.13	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1043.05	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1043.05			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -1043.05)